

# Methods Listing

Thorud Inc.

4647C80G01

T

CAP ASSEMBLY BOTTOM

3-WAY VALVE  
MACHINED

Type:  
Mfg

Group:  
TKVAL

Class:  
3WAY

**0 - 1 4647C80G01 CAP ASSEMBLY BOTTOM**

Parent assembly: 0

Qty per parent assembly: 1.00

Unit of Measure: EA

Revision: T

**Materials:**

Qty required for Operation L/days

2 2098B73G01  
Ware House

AM

Shelf

Cap Assemble Bottom 3 Way Valve 1.000 EA

0 0

**Operations:**

Qty Setup Time Prod Time

2	INSP	CONTL	CONTROL PLAN USE CONTROL PLAN I.S.S. DATED 4/1/2012	1.00	0.00	0.00TD
10	NAK1	TURN	Turning FILE# TK4647C80.010 USE TOOL SEQ. DATED 4/5/2012 MACHINE FRONT SIDE COMPLETE (BORE SIDE) ON BOTH THE MAIN SPINDLE AND THE SUB SPINDLE	1.00	5.00	55.00PH
15	HAAS4	MILL	Clamping pressure on the gage should read 2.0 Milling FILE# TK4647C80.015 USE TOOL SEQ. DATED 4/1/2012 USE FIXTURE FOR THIS JOB # TK4647C80 .125 PIN ON LEFT SIDE OF FIXTURE IN MACHINE	1.00	2.00	40.00PH
30	ULT1	USW#1	Ultrason (wash parts)	1.00	0.00	250.00PH
40	INSP	FINSP	Final Inspection Sampling of finished product either prior to shipping or prior to stocking in inventory.	1.00	0.00	0.00PH
50	SHRE	SHIP	Shipping TAKE PARTS TO ASSEMBLY FOR ASSY PART # 5D46543G01	1.00	0.25	0.00TD